

# Work Order ID 48264

June 29, 2009 12:57:54 PM



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Item ID: K10003  
Revision ID: F  
Item Name: Saddle, D205-634-011

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 4.00  
Required Date: 03/08/2009 Req'd Qty: 4.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN634,635	Rev F

100 0.00



DC

DOCUMENT CONTROL

Memo

0209107/01

0.00

Document Control

Create White labels only per PPP K10003

CHG 0067

110 0.00



Packaging

Pick Kit

Memo

0.00

Packaging

Rev 2 9/16/11 4x SP

120 0.00



QC

QC4- 100% Inspect kits for completeness

Memo

0.00

Quality Control

80267/01 (R)

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Page 1

**Parent Item:** K10003RevF

**Parent Item Name:** Saddle, D205-634-011

**Comments:**

**Start Date:** 15/07/2009

**Required Date:** 03/08/2009

**Start Qty: 4.00 .**

**Required Qty: 4.00**

[illegible]

# Picklist Print

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Work Order ID: 48264

Parent Item: K10003RevF

Parent Item Name: Saddle, D205-634-011



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
8 (40) D2573RevE +1 		Manufactured	No		9/6/30		Each	25.0000	4.0000	48334		SP
Saddle, Aft Out 205												
8 (40) D2574RevE +1 		Manufactured	No		9/6/30		Each	12.0000	4.0000	48355 <sup>(3)</sup>		B39476 SP
Saddle, Aft In 205												
8 (40) D2747RevB *4 		Manufactured	No		9/6/30		Each	305.0000	16.0000	43855		SP
Set Screw												
8 (40) D2876RevB *2 		Manufactured	No		9/6/30		Each	238.0000	8.0000	42364		SP
Saddle Spacer												
8 (40) D2877RevB *2 		Manufactured	No		9/6/30		Each	179.0000	8.0000	43857		SP
Saddle Spacer												
-3 (40) D3405-041RevB +1 		Manufactured	No		9/6/30		Each	27.0000	4.0000	47427 <sup>(3)</sup>		SP
Lug Assembly												
8 (40) D3405-043RevB +1 		Manufactured	No		9/6/30		Each	28.0000	4.0000	<del>47208</del> 8 47308		SP
Lug Assembly												
8 (40) D3407-041RevE +1 		Manufactured	No		9/6/30		Each	28.0000	4.0000	48356		SP
Tow Ring												
8 (40) D3417-5RevD *2 		Manufactured	No		9/6/30 (4x)		Each	33.0000	8.0000	B34591		SP
Washer												

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Shop Packet Print

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# Picklist Print

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Work Order ID: 48264

Parent Item: K10003RevF

Parent Item Name: Saddle, D205-634-011

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S 40 D3456-1RevA Washer	X1	Manufactured	No		9/6/30		Each	70.0000	4.0000	B46752		SD
S 8 D3533-1RevB Set Screw	X2	Manufactured	No		9/6/30		Each	110.0000	8.0000	47625		SD
S 40 MS21042L4 Nut	X24	Purchased	No		9/6/30		Each	9,086.000	96.0000	(18) M108145	(78x) M110S07	SD
S 40 MS21043-4 Nut	X5	Purchased	No		9/6/30		Each	276.0000	20.0000	M111819		SD

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Shop Packet Print

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Date: Thursday, 28/05/2009 9:13:50 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE KIT
<b>Job Number</b> : 48264	
<b>Estimate Number</b> : 10532	
<b>P.O. Number</b> :	<b>Part Number</b> : K10003
<b>This Issue</b> : 28/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : 634, 635 IIN
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 47540	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 04/06/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.05.28</u>	
<b>Comment</b> : Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by: Est N 09.01.27 DSI 9418 rev B EC verified by: DD Est P 09.04.20 fixed pick list EC verified by: DD	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 006

2.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2570

Bushing

**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	

4.0

D2571

Saddle, Fwd Out 205

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48264

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	

8.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Lug Assembly

9.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Lug Assembly

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 28/05/2009 9:13:51 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48264

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	

13.0

D3533f

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Set Screw

Batch:

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)  
Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

15.0

AN4C47A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)  
BOLT

batch:

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)  
Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48264

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

✓ AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	

18.0

✓ AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 128.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	

19.0

✓ AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	

20.0

✓ MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Nut

Batch: \_\_\_\_\_

21.0

✓ D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tow Ring

batch: \_\_\_\_\_

22.0

✓ D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 28/05/2009 9:13:51 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48264

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS210434

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

batch: \_\_\_\_\_

24.0

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: \_\_\_\_\_

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ATNO 30000000

## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

Date: Wednesday, 01/07/2009 8:50:01 AM

User: Melanie Fauteux

# Bill of Manufacturing

Part Number : K10003  
Drawing Name : SADDLE KIT

Revision : F  
Default Qty. : 1

NO LONGER  
REFERENCE ONLY

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	43.00	0.00
2	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
3	D2570	Bushing	<del>24.00</del>	Each	1.17	28.08
4	D2571	Saddle, Fwd, Out	<del>1.00</del>	Each	171.58	171.58
5	D2572	Saddle, Fwd, In	<del>1.00</del>	Each	129.22	129.22
6	D2573	Saddle, Aft, Out	<del>1.00</del>	Each	151.80	151.80
7	D2574	Saddle, Aft, In	<del>1.00</del>	Each	115.99	115.99
8	D3405041	Lug Assembly	<del>1.00</del>	Each	87.52	87.52
9	D3405043	Lug Assembly	<del>1.00</del>	Each	66.88	66.88
10	D2747	Set Screw	<del>4.00</del>	Each	0.68	2.72
11	D2876	Saddle Spacer	<del>2.00</del>	Each	0.98	1.96
12	D2877	Saddle Spacer	<del>2.00</del>	Each	1.14	2.28
13	D35331	Set Screw	<del>2.00</del>	Each	0.00	0.00
14	AN46A	Bolt	<del>16.00</del>	Each	0.07	1.12
15	AN4C47A	BOLT	<del>4.00</del>	Each	20.46	81.86
16	AN451A	Bolt	<del>8.00</del>	Each	3.74	29.92
17	AN612A	Bolt	<del>8.00</del>	Each	0.40	3.20
18	AN960JD416	Washer	<del>32.00</del>	Each	0.03	0.96
19	AN960JD616	Washer	<del>8.00</del>	Each	0.08	0.64
20	MS21042L4	Nut	<del>24.00</del>	Each	0.09	2.16
21	D3407041	Tow Ring	<del>1.00</del>	Each	73.97	73.97
22	D34561	Washer	<del>1.00</del>	Each	0.23	0.23
23	MS210434	Nut	<del>5.00</del>	Each	0.52	2.64
24	D34175	Washer	<del>2.00</del>	Each	3.36	6.73
25	QC4	INSPECT KITS 100% FOR COMPLETENESS	0.00	Hours	0.00	0.00
26	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	56.00	0.00
27	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						961.51